

Work Order ID 66576

Tuesday, February 22, 2011 11:06:57 AM



Page 1

Item ID:	D3255-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Access Panel Assembly					
Start Date:	2/23/2011	Start Qty:	4.00		Cust Item ID:	
Required Date:	3/9/2011	Req'd Qty:	4.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>CMK</u>	Date:	<u>11-02-22</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3255	Rev B								

100		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Weld as per Dwg D3255 ***purge weld*** <input type="checkbox"/> A/R SS ROD								
	Batch: <u>115928</u> <input type="checkbox"/> 2-Grind Welds Flush								

CP 11.04.09

110		0.00							
	QC10- Inspect visual per QSI004- ground welds								
QC	Memo	0.00							
Quality Control									

Sub 02/11

120		0.00							
	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									

Sub 02/11

CP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66576

Tuesday, February 22, 2011 11:06:57 AM



Page 2

Item ID: D3255-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Access Panel Assembly

Start Date: 2/23/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 3/9/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Powdercoat

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

MUS 128.

Memo

0.00

Powder Coating

START TIME:

10:05

OVEN TEMPERATURE:

FINISH TIME:

10:35

4

BL 11-4-11

140



QC

QC3- Inspect Part Finish

0.00

Memo

0.00

Quality Control

4 d Ill 11/04/11

150



Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

1-Bond D3255-5 gasaket to d3255-041 using Dow corning adhesive as per Dwg

D3255 A/R 736

DOW CORNING ADHESIVE

Batch: M11664

(4)

JB 11/04/11

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Page 3

Item ID: D3255-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Access Panel Assembly

Start Date: 2/23/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 3/9/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/16/18

(x4)

241

170

Identify as per dwg & Stock Location: 176

0.00



Packaging

Memo

0.00

Packaging

1/14/18 (G)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/18

11.02.18

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NOTE: Date & initial all entries

Picklist Print

Tuesday, February 22, 2011 11:06:54 AM

Page 1

Work Order ID: 66576

Parent Item: D3255-041

Parent Item Name: Access Panel Assembly




Start Date: 2/23/2011

Required Date: 3/9/2011


Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:C Removed Manufacturing of D3255-1/-2/-3 06-08-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3255-1 		Manufactured	No			100	Each	0.0000	1	4			
Panel													
D3255-3 		Manufactured	No			150	Each	6.0000	1	4			
Cap													
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>WA</div> <div>2</div> <div></div> </div>													
<div> <div>48315</div> <div>2</div> <div></div> </div>													
<div> <div>WA21</div> <div>4</div> <div></div> </div>													
<div> <div>63587</div> <div>4</div> <div></div> </div>													
D3255-5 		Manufactured	No			100	Each	5.0000	1	4			
Gasket													

 B66573 → ④ 11-04-07

 B63587 → ④ 11-04-07

80 11/04/17

Location	Loc Qty	Loc Code
ST044	5	
63588	5	
66574		

2
2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

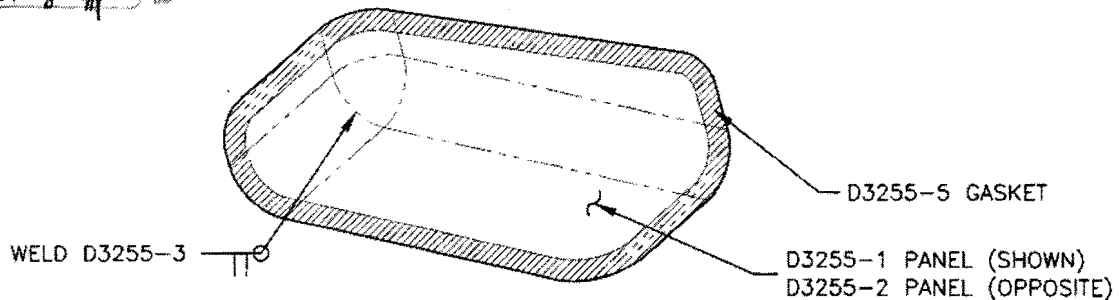
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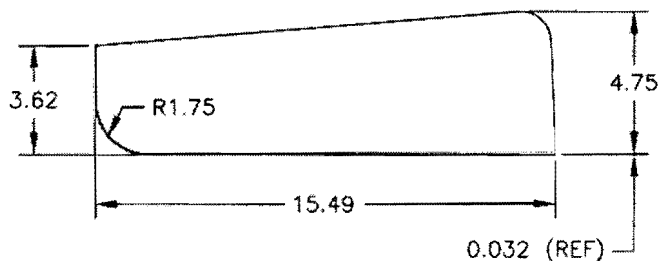
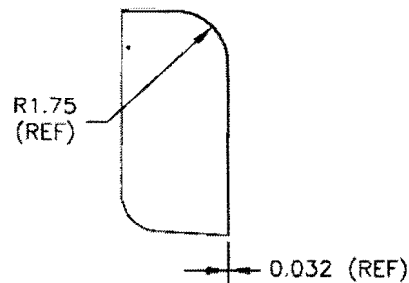
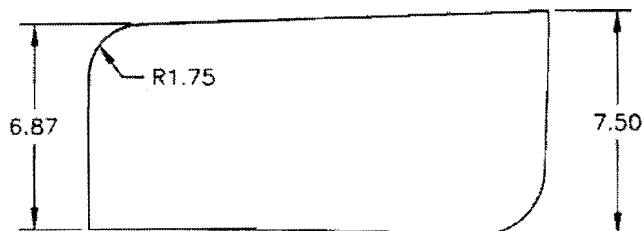


DESIGN R#	DRAWN BY R#	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED if	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 1 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:6
A	04.01.27	NEW ISSUE	
B	04.12.06	D3255-3 REDESIGN; ADDED $\phi 0.098$	

RELEASED
05-01-18 #



D3255-041 ACCESS PANEL (SHOWN)
D3255-042 ACCESS PANEL (OPPOSITE)



D3255-1 BEND DETAIL
D3255-2 OPPOSITE

D3255-041/-042 NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

#60576

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

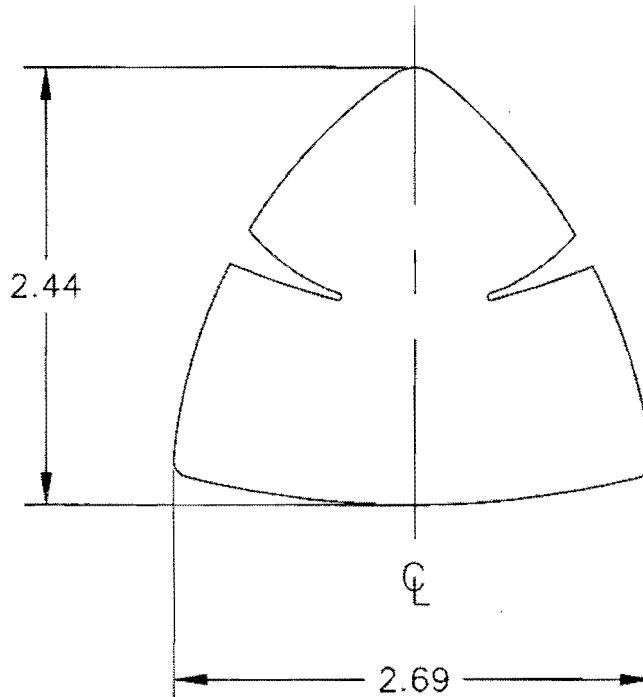
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DESIGN RT	DRAWN BY JH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED JH	DRAWING NO. D3255	REV. B SHEET 2 OF 4
DATE 04.12.06	TITLE TITLE		SCALE 1:1

RELEASED
05-01-08 #



D3255-3 CAP
FORM TO FIT D3155-1/-2

D3255-3 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

#66576

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

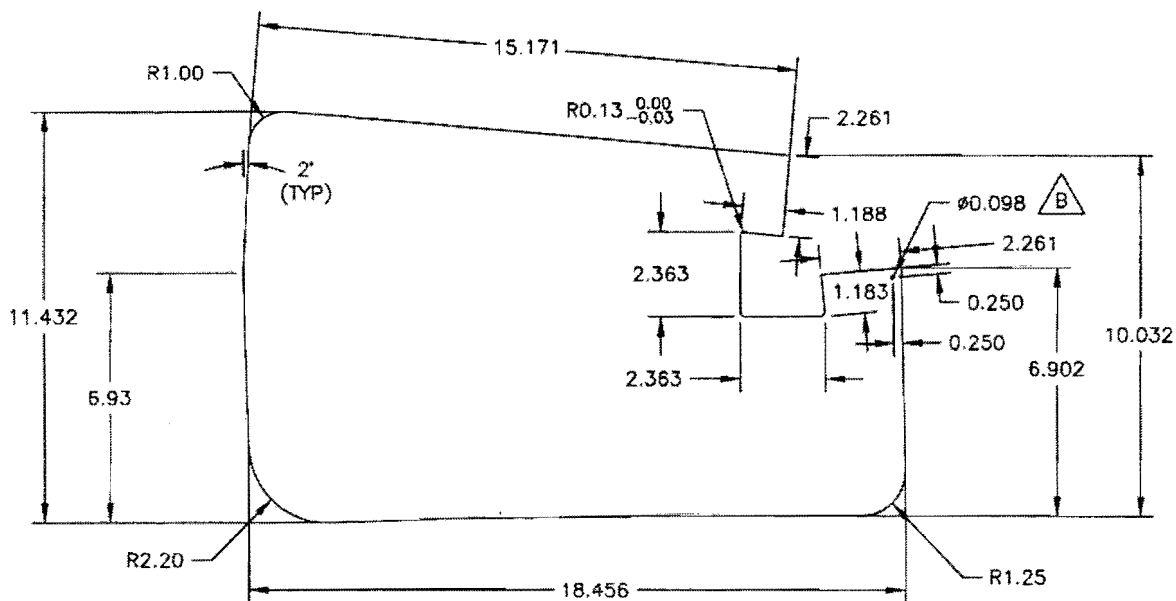
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NOTE: Date & initial all entries



DESIGN RF	DRAWN BY TF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 3 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED
05-01-18



D3255-1/-2 FLAT PATTERN

D3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Dart Aerospace Ltd

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